

Date: Friday, 11/16/2007 7:20:59 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : END PLATE  
 Job Number : 35804  
 Estimate Number : 10547  
 P.O. Number : N/A Part Number : D30671  
 This Issue : 11/16/2007 S.O. No. : N/A Drawing Number : D3067 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : 35079 Material : N/A  
 Written By : 07/11/16 Due Date : 11/30/2007 Qty: 237 Um: Each  
 Checked & Approved By : 07/11/16  
 Comment : Est:03.01.24 Remove step 6 (Deburr) KJ  
 Est Rev:B Now on Water jet 06-06-16 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S063 5052-H32 .063 Sheet



Comment: Qty.: 0.0656 sf(s)/Unit Total : 10.5000 sf(s)  
 5052-H32 .063 Sheet  
 Material: 5052-H32 (QQ-A-250/8)  
 M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)  
 Batch:

103713 IB 07-11-20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3067  
 Dwg Rev: A  
 Prog Rev: A

IB 07-11-20

238

2-Deburr if necessary

07/11/21 238 Counted 88

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 07-11-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



counted

Comment: SECOND CHECK

07/12/06

238

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
 Bend as per Dwg D3067

07/12/06 237

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DD Date: 07/12/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END PLATE

Job Number: 35804

Part Number: D30671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



QSP019



counters

Comment: INSPECT WORK TO NEXT STEP

2/12/06

237

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

11/07/12/06

237

8.0

QC21

FINAL INSPECTION/W/O RELEASE



237

Comment: FINAL INSPECTION/W/O RELEASE

11/07/12/06

Job Completion



11/07/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

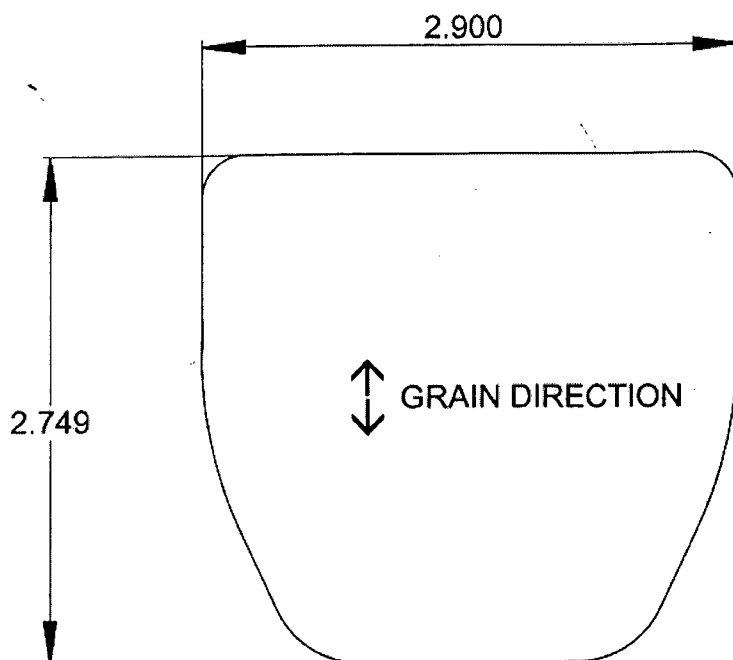
NOTE: Date & initial all entries



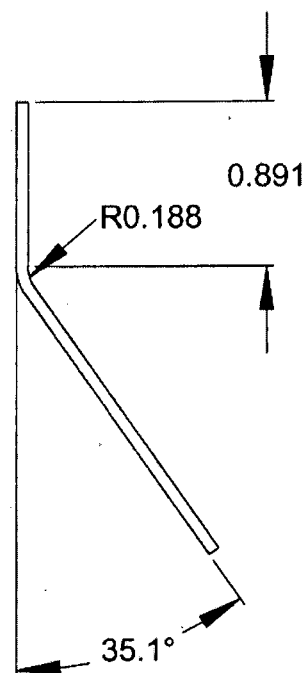


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. <b>D3067</b>	REV. A SHEET 1 OF 1
DATE <b>02.09.11</b>		TITLE <b>END PLATE</b>	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED  
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)  
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)  
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **35804**

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